

IN THE CLAIMS:

Cancel claims 1-12, and insert therefor the following
new claims:

--13. A method for manufacturing a fibrous cellulose
sausage casing, which method comprises:

forming a wet-strengthened manila based paper material,
which paper is wet-strengthened by at least one strengthener
selected from the group consisting of resins and viscose into the
shape of a tubing, the weight of which paper is less than ¹⁴/₁₇
g/m²;

impregnating said tubing with viscose; and coagulating
the viscose into cellulose by passing the impregnated tubing
through at least one acid and salt bath; and,
plasticizing the treated tubing.

14. The method as claimed in claim 13, wherein the
paper used is wet-strengthened by resins having a lower basis
weight than the basis weight of paper wet-strengthened by viscose
alone or viscose used in conjunction with small amounts of resins
in order to achieve elasticity properties substantially similar
to one another.

15. The method as claimed in claim 13, wherein the
weight of the resin bonded paper is reduced by about 1 to 4g/m²
in comparison to paper wet-strengthened by viscose alone or
viscose plus small amounts of resins, in order to obtain
elasticity properties substantially similar to one another.

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16. The method as claimed in claim 13, wherein the weight of the resin bonded paper is reduced by about 2-3g/m² in comparison to paper wet-strengthened by viscose alone or viscose plus small amounts of resins, in order to obtain elasticity properties substantially similar to one another.

17. The method as claimed in claim 13, which comprise the steps of:

feeding the viscose under pressure through the lips of a die directly onto one surface of the tubing and through the paper base or substrate, which paper base or substrate has a weight of 15g/m² or less,

supporting the paper on its underside during transit across the lips by a metal ring or cylinder, wherein the gap between ring and die allows the paper to pass unimpeded,

impregnating the paper substrate by continuing the passage of the tube between die and supporting ring for a predetermined distance within fixed cap dimensions, thereby continuously impregnating the paper substrate.

18. The method as claimed in claim 17, wherein the impregnating die is situated outside of the tube with the support inside the tube.

19. The method as claimed in claim 13, wherein the paper substrate is wet-strengthen using resins, which substrate is impregnated by viscose in the impregnation stage, while the paper weight is less than 13g/m².

20. The method as claimed in claim 13, wherein the paper substrate is wet-strengthen using resins, which substrate is impregnated by viscose in the impregnation stage, while the paper weight is from 10 to 12g/m².

21. The method as claimed in claim 17, wherein the die has an annular opening against the tube, the distance between the faces of the lips and the surface of the supporting ring being 0.5 to 0.7 mm, that is the passage through which the substrate paper travels.

22. The method as claimed in claim 17, wherein the die has an annular opening against the tube, the distance between the faces of the lips and the surface of the supporting ring being 0.55 to 0.66 mm, that is the passage through which the substrate paper travels.

23. The method as claimed in claim 17, wherein the length of the supporting ring is from 10 to 25 mm, which extends to a distance horizontal to the lower end of the lower lip of the die.

24. The method as claimed in claim 17, wherein the annular opening of the die is located in the lower part of the die thereby permitting the viscose to be fed in the lower part of the die.

25. The method as claimed in claim 17, wherein the paper lead-in distance between paper supporting ring and the upper end of the upper lip of the viscose die, to the point of

the viscose issue at the lower end of the upper lip is between 10 and 5 mm, while the distance on the paper lead-outside, between the point of viscose issue and the lower end of the lower lip is between 10 and 2 mm.

26. The method of continuously impregnating a paper substrate formed into a tube shape, which method comprises the steps of:

feeding the viscose under pressure through the lips of the die directly onto one surface and through the paper base or substrate having a weight of less than 15g/m^2 ,

supporting the paper substrate from the side opposite the die during transit across these lips by a metal ring or cylinder, the gap between ring and die being such that it permits the paper to pass unimpeded, and

continuing the impregnation of the paper substrate by continuing the passage of the tube between die and supporting ring for a predetermined distance within fixed gap dimensions.

27. The tubing manufactured by the method is claimed in claim 13, which tubing comprises viscose and which tubing is wet-strengthened by at least one strengthener selected from the group consisting of resins and viscose, which has a basis weight of less than 15g/m^2 .

28. The tubing as claimed in claim 27, wherein the basis weight of said paper material is from 10 to 13g/m^2 .